



Dart Aerospace Ltd.  
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Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

004178

**D119-796-021**  
**Job Sheet 174909**



**Part No:** D119-796-021

**Job Qty:** 1 ea

**Part Name:** AW119 Standard Landing Gear Assembly - Standard OEM Protection



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 3/23/18

**Job Tracking No:**

**Due Date:** 7/4/18

**Created By:** Michelle Gagnon-Donovan

**Type:** SOLD

**Description:**

**Note:** DWG D119-796-021 REV A, IIN-D119-796 REV F IPP REV:A NEW ISSUE 15-05-012 JLM VERIFIED BY:DD  
IPP REV:B 15.08.25 AS PER IIN REV:E DD VERF:JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 90    | Start up Operation | 1 Ea  | 7/3/18     | 7/3/18   | 0.00      | 0.00    | Start Up Stores/Pkg-1 |           | JLM 03 2018 |
| 100   | Packaging          | 1 pcs | 7/3/18     | 7/3/18   | 0.00      | 0.00    | Packaging1-1          |           |             |
| 110   | HandFinish         | 1 pcs | 7/4/18     | 7/4/18   | 0.00      | 6.25    | HandFinish4           |           | DAS         |
| 120   | QC                 | 1 pcs | 7/4/18     | 7/4/18   | 0.00      | 0.00    | QC5                   |           | 38          |
| 130   | Packaging          | 1 pcs | 7/4/18     | 7/4/18   | 0.00      | 0.00    | Packaging3-1          |           | 9-89        |
| 140   | QC21-FG            | 1 Ea  | 7/4/18     | 7/4/18   | 0.00      | 0.00    | QC21                  |           |             |

Part Op 100 - Photocopy bluefile and create labels as per PPP D119-796-021 chg 003/ D119-646-041 paperwork  
Descriptions: 110 - ASSEMBLE AS PER DWG AND NOTES 8,9,10,11 ASSEMBLE WITH PROSEAL BATCH: \_\_\_\_\_ 2-INSTALL  
DECAL D2729-4

130 - Identify and pack for shipping as per PPP D119-796-021 Location: \_\_\_\_\_ PPP Rev: \_\_\_\_\_



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**Container No:** S088648



**Part:** D119-796-021

**Job No:** 174909

**Serial No/Batch:** S088648

**Revision:** A / F

**Inspector:**

**Exp Date:**

**Instructions:**

**Date:** 07/03/18

## Job BOM

| Part / Item   | Component Name                                           | Quantity      | Operation             | Container         |
|---------------|----------------------------------------------------------|---------------|-----------------------|-------------------|
| AN3C46A       | Bolt                                                     | 8 Ea (8 ea)   | 90-Start up Operation | 5024836           |
| AN3C50A       | Bolt                                                     | 16 Ea (16 ea) | 90-Start up Operation | 5076374           |
| AN4C6A        | Bolt                                                     | 24 Ea (24 ea) | 90-Start up Operation | 5027575           |
| D2652         | Bushing                                                  | 48 Ea (48 ea) | 90-Start up Operation | 5033368437        |
| D3407-041     | Tow Ring                                                 | 2 Ea (2 ea)   | 90-Start up Operation | 5080752           |
| D3417-5       | Washer                                                   | 4 Ea (4 ea)   | 90-Start up Operation | 5070284           |
| D3456-1       | Washer                                                   | 2 Ea (2 ea)   | 90-Start up Operation | 5079335           |
| D3672-3       | Washer, Phenolic                                         | 48 Ea (48 ea) | 90-Start up Operation | 5027022           |
| D3672-7       | Washer, Phenolic                                         | 48 Ea (48 ea) | 90-Start up Operation | 5157442           |
| D3883-1       | Saddle, Outboard LH                                      | 2 Ea (2 ea)   | 90-Start up Operation | 5081017           |
| D3883-2       | Saddle, Outside RH                                       | 2 Ea (2 ea)   | 90-Start up Operation | 5081399           |
| D3884-1       | Saddle, Inside LH                                        | 2 Ea (2 ea)   | 90-Start up Operation | 5069205           |
| D3884-2       | Saddle, Inside RH                                        | 2 Ea (2 ea)   | 90-Start up Operation | 5080306           |
| D3886-041     | Lug Assembly                                             | 4 Ea (4 ea)   | 90-Start up Operation | 5072751           |
| MS21043-3     | Nut                                                      | 24 Ea (24 ea) | 90-Start up Operation | 5062620           |
| MS21043-4     | Nut                                                      | 26 Ea (26 ea) | 90-Start up Operation | 5062296           |
| MS21043-5     | Nut                                                      | 8 Ea (8 ea)   | 90-Start up Operation | 5024470           |
| MS21250-05048 | Bolt (Use Ms21250-05-048)                                | 8 Ea (8 ea)   | 90-Start up Operation | 5076663           |
| MS21920-28    | Clamp                                                    | 2 Ea (2 ea)   | 90-Start up Operation | 5071412K1         |
| NAS1149C0332R | Washer                                                   | 24 Ea (24 ea) | 90-Start up Operation | 5049837           |
| NAS1149C0432R | Washer                                                   | 48 Ea (48 ea) | 90-Start up Operation | 5050052           |
| NAS1149C0532R | Washer                                                   | 16 Ea (16 ea) | 90-Start up Operation | 5055951           |
| D119-646-041  | AW119 Replacement Skidtube with Wearpads - Fits LH or RH | 2 Ea (2 ea)   | 110-HandFinish        | 5078101x 5059831x |
| D119-796-151  | Fwd Crosstube Installation With Step (No Hardware)       | 1 Ea (1 ea)   | 110-HandFinish        | 5090095           |
| D119-796-251  | Aft Crosstube Installation With Step (No Hardware)       | 1 Ea (1 ea)   | 110-HandFinish        | 5090099           |

## Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | AN3C46A        | 8        | 197       | 0         |
|                       | AN3C50A        | 16       | 116       | 0         |
|                       | AN4C6A         | 24       | 427       | 0         |
|                       | D2652          | 48       | 532       | 0         |
|                       | D3407-041      | 2        | 14        | 0         |
|                       | D3417-5        | 4        | 35        | 0         |
|                       | D3456-1        | 2        | 105       | 0         |
|                       | D3672-3        | 48       | 1,278     | 0         |
|                       | D3672-7        | 48       | 595       | 0         |
|                       | D3883-1        | 2        | 8         | 0         |
|                       | D3883-2        | 2        | 2         | 0         |
|                       | D3884-1        | 2        | 11        | 0         |
|                       | D3884-2        | 2        | 10        | 0         |
|                       | D3886-041      | 4        | 18        | 0         |
|                       | MS21043-3      | 24       | 951       | 0         |
|                       | MS21043-4      | 26       | 631       | 0         |
|                       | MS21043-5      | 8        | 151       | 0         |
|                       | MS21250-05048  | 8        | 5         | 0         |
|                       | MS21920-28     | 2        | 85        | 0         |
|                       | NAS1149C0332R  | 24       | 4,896     | 0         |
| 110-HandFinish        | NAS1149C0432R  | 48       | 2,911     | 0         |
|                       | NAS1149C0532R  | 16       | 189       | 0         |
|                       | D119-646-041   | 2        | 2         | 0         |
|                       | D119-796-151   | 1        | 0         | 0         |
|                       | D119-796-251   | 1        | 0         | 0         |

## Part Specifications

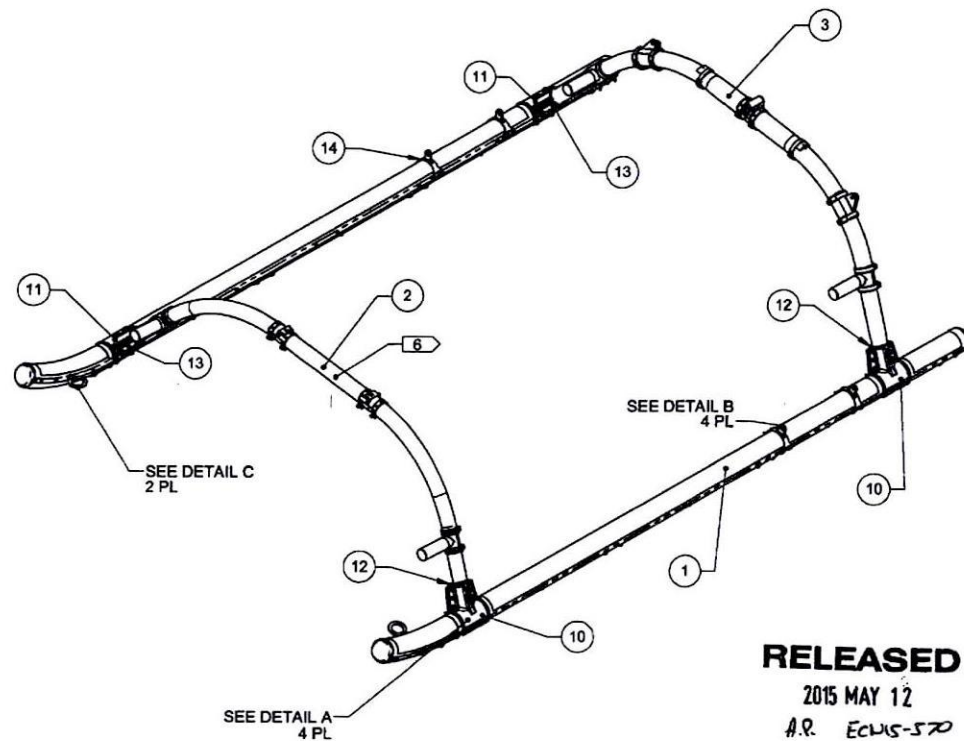
Specifications could not be found.

Plex 3/23/18 9:10 AM Dart.Gagnon.Michelle



| ITEM | QTY | P/N           | DESCRIPTION                    |
|------|-----|---------------|--------------------------------|
|      | X   | D119-796-021  | STD GEAR WITH STD WEARPADS     |
| 1    | 2   | D119-646-041  | STD SKIDTUBE WITH STD WEARPADS |
| 2    | 1   | D119-796-151  | XTUBE ASSY (AW119 MKII FWD)    |
| 3    | 1   | D119-796-251  | XTUBE ASSY (AW119 MKII AFT)    |
| 4    | 48  | D2652         | BUSHING                        |
| 5    | 2   | D3407-041     | TOW RING                       |
| 6    | 4   | D3417-5       | WASHER                         |
| 7    | 2   | D3456-1       | WASHER                         |
| 8    | 48  | D3672-3       | PHENOLIC WASHER                |
| 9    | 48  | D3672-7       | PHENOLIC WASHER                |
| 10   | 2   | D3883-1       | SADDLE, OUTBOARD LH            |
| 11   | 2   | D3883-2       | SADDLE, OUTBOARD RH            |
| 12   | 2   | D3884-1       | SADDLE, INBOARD LH             |
| 13   | 2   | D3884-2       | SADDLE, INBOARD RH             |
| 14   | 4   | D3886-041     | LUG ASSEMBLY                   |
| 15   | 8   | AN3C46A       | BOLT                           |
| 16   | 16  | AN3C50A       | BOLT                           |
| 17   | 24  | AN4C6A        | BOLT                           |
| 18   | 24  | MS21043-3     | NUT, SELF-LOCKING              |
| 19   | 26  | MS21043-4     | NUT, SELF-LOCKING              |
| 20   | 8   | MS21043-5     | NUT, SELF-LOCKING              |
| 21   | 8   | MS21250-05048 | BOLT                           |
| 22   | 24  | NAS1149C0332R | WASHER                         |
| 23   | 48  | NAS1149C0432R | WASHER                         |
| 24   | 16  | NAS1149C0532R | WASHER                         |

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NO. 174909  
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D119-796-021 STD GEAR WITH STD WEARPADS

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2015 MAY 12

A.R. ECWS-570

|            |          |                                                                                                                                                                                                                                                                                 |              |    |          |
|------------|----------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|----|----------|
| A          |          | NEW ISSUE                                                                                                                                                                                                                                                                       |              | AP | 15.04.01 |
| REV.       |          | DESCRIPTION                                                                                                                                                                                                                                                                     |              | BY | DATE     |
| DESIGN     | AP       | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                               |              |    |          |
| DRAWN      | AP       |                                                                                                                                                                                                                                                                                 |              |    |          |
| CHECKED    | AJS      | DRAWING NO.                                                                                                                                                                                                                                                                     | REV. A       |    |          |
| MFG. APPR. | DD       | D119-796-021                                                                                                                                                                                                                                                                    | SHEET 1 OF 4 |    |          |
| APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                           | SCALE        |    |          |
| DE APPR.   | DS       | STD GEAR WITH STD WEARPADS                                                                                                                                                                                                                                                      | NTS          |    |          |
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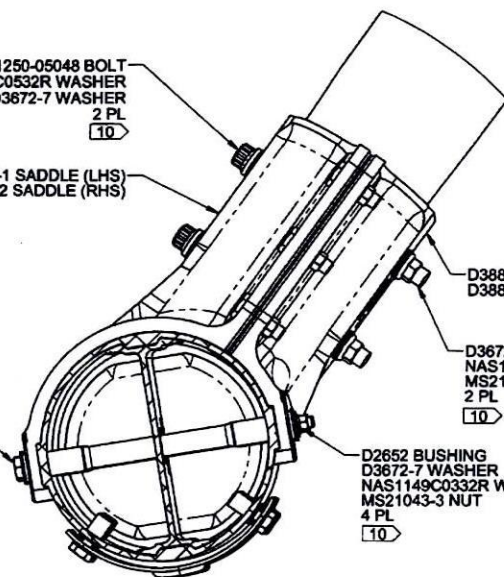
APPROVED

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: N/A  
4) UNITS: N/A  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: INSTALL D2729-4 RED DECAL IN LOCATION SHOWN  
7) WEIGHT: 122.7 LBS

MS21250-05048 BOLT  
NAS1149C0532R WASHER  
D3672-7 WASHER  
2 PL  
10

D3883-1 SADDLE (LHS)  
D3883-2 SADDLE (RHS)

AN3C50A BOLT  
D3672-7 WASHER  
D2652 BUSHING  
4 PL  
10



D3884-1 SADDLE (LHS)  
D3884-2 SADDLE (RHS)

D3672-7 WASHER  
NAS1149C0532R WASHER  
MS21043-5 NUT  
2 PL  
10

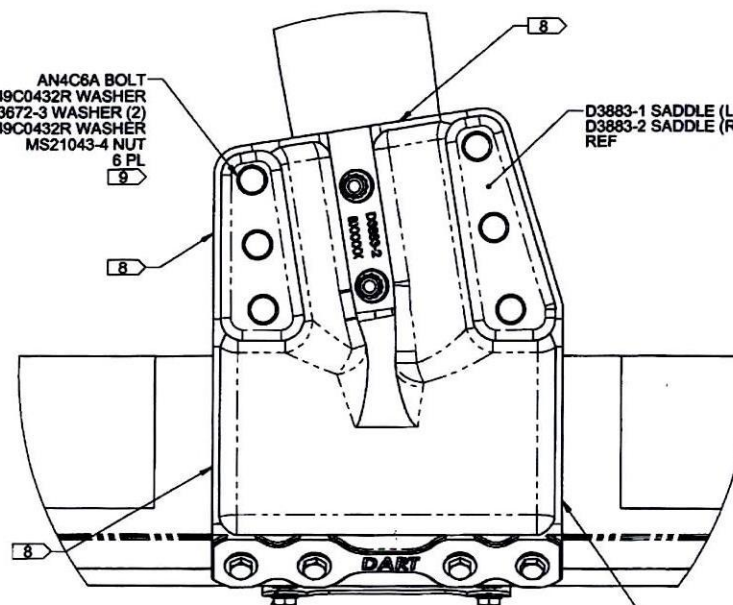
D2652 BUSHING  
D3672-7 WASHER  
NAS1149C0332R WASHER  
MS21043-3 NUT  
4 PL  
10



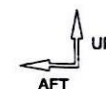
**DETAIL A**  
4 PL

AN4C6A BOLT  
NAS1149C0432R WASHER  
D3672-3 WASHER (2)  
NAS1149C0432R WASHER  
MS21043-4 NUT  
6 PL  
9

D3883-1 SADDLE (LHS)  
D3883-2 SADDLE (RHS)  
REF



**DETAIL A**



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2015 MAY 12

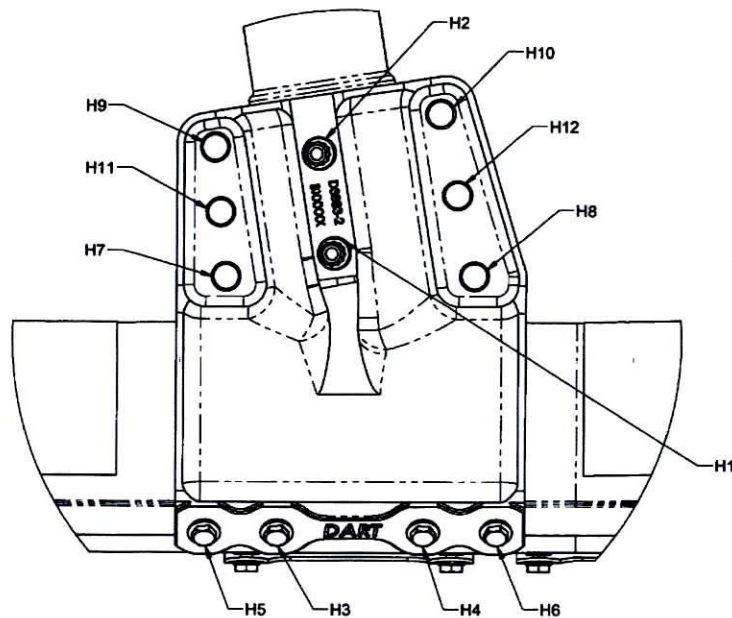
A.P. EN 15-570

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A CONTINUOUS BEAD OF SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT IN THE LOCATIONS SHOWN INCLUDING THE FOLLOWING:
  - A) ALONG SADDLE/CROSSTUBE INTERFACE
  - B) BETWEEN THE SADDLE FLANGES
  - C) ALONG SADDLE/SKIDTUBE INTERFACE
- 9) LIGHTLY TIGHTEN ALL BOLTS IN THE NUMERICAL ORDER SPECIFIED ON SHEET 3, THEN TIGHTEN TO SPECIFIED TORQUE IN TABLE 1.
- 10) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) ALL NUTS TO BE INSTALLED ON THE INBOARD SIDE

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|                                                                                                                                                                                                                                     |          |                                        |              |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|----------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                              | AP       | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                               | AP       | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                             | AJS      | DRAWING NO.                            | REV. A       |
| MFG. APPR.                                                                                                                                                                                                                          | DD       | D119-796-021                           | SHEET 2 OF 4 |
| APPROVED                                                                                                                                                                                                                            | HS       | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                            | DS       | STD GEAR WITH STD WEARPADS             | NTS          |
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**SUPPLEMENTAL VIEW - TORQUE SEQUENCE**

**TABLE 1: TORQUE SEQUENCE AND MAX TORQUE**

| TORQUE SEQUENCE | PART NUMBER   | TORQUE                       |
|-----------------|---------------|------------------------------|
| H1              | MS21250-05048 | 66-85 IN-LBS (7.3 - 9.6 N-m) |
| H2              | MS21250-05048 | 66-85 IN-LBS (7.3 - 9.6 N-m) |
| H3              | AN3C50A       | 15-25 IN-LBS (1.7 - 9.6 N-m) |
| H4              | AN3C50A       | 15-25 IN-LBS (1.7 - 9.6 N-m) |
| H5              | AN3C50A       | 15-25 IN-LBS (1.7 - 9.6 N-m) |
| H6              | AN3C50A       | 15-25 IN-LBS (1.7 - 9.6 N-m) |
| H7              | AN4C8A        | 50-70 IN-LBS (5.7 - 7.9 N-m) |
| H8              | AN4C8A        | 50-70 IN-LBS (5.7 - 7.9 N-m) |
| H9              | AN4C8A        | 50-70 IN-LBS (5.7 - 7.9 N-m) |
| H10             | AN4C8A        | 50-70 IN-LBS (5.7 - 7.9 N-m) |
| H11             | AN4C8A        | 50-70 IN-LBS (5.7 - 7.9 N-m) |
| H12             | AN4C8A        | 50-70 IN-LBS (5.7 - 7.9 N-m) |

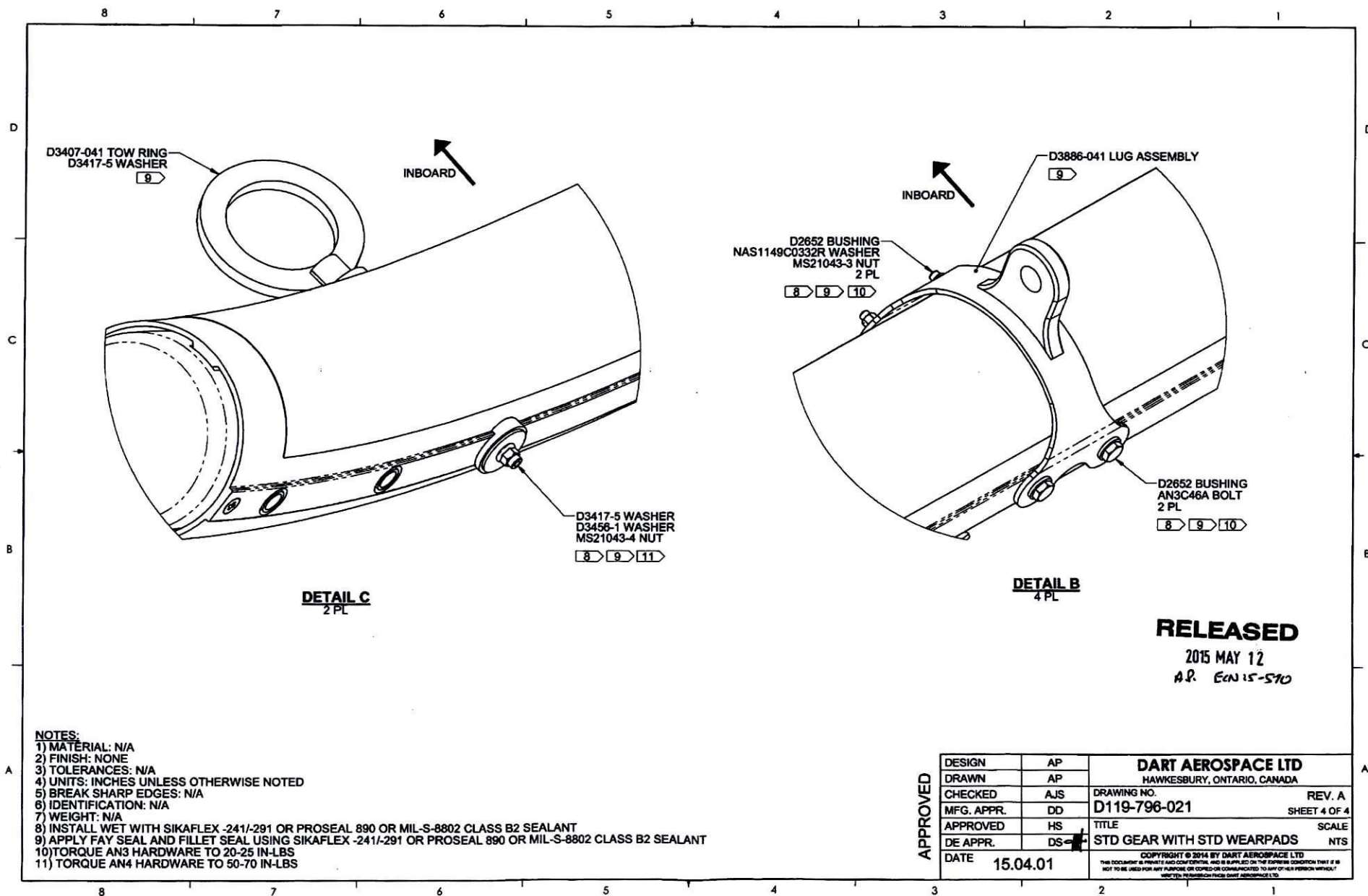
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A.R. EN 15-570

|          |            |          |                                                                                                                                                                                                                                                                                                                                           |              |
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| APPROVED | DESIGN     | AP       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                                                  |              |
|          | DRAWN      | AP       |                                                                                                                                                                                                                                                                                                                                           |              |
|          | CHECKED    | AJS      | DRAWING NO.                                                                                                                                                                                                                                                                                                                               | REV. A       |
|          | MFG. APPR. | DD       | D119-796-021                                                                                                                                                                                                                                                                                                                              | SHEET 3 OF 4 |
|          | APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                                                                                     | SCALE        |
|          | DE APPR.   | DS       | STD GEAR WITH STD WEARPADS                                                                                                                                                                                                                                                                                                                | NTS          |
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|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                       |                                                       |                                                                                                                                                                                                                                                                                                                                            |                          |                                                     |                                   |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------|-------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------|-----------------------------------------------------|-----------------------------------|
| 1. Approving Civil Aviation Authority/Country<br><b>Transport Canada</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                       | 2. <b>AUTHORIZED RELEASE CERTIFICATE<br/>Form One</b> |                                                                                                                                                                                                                                                                                                                                            |                          | 3. Form Tracking Number:<br><br>S0-4663-03          |                                   |
| 4. Organizations Name and Address:<br><br><b>Dart Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario, K6A 1K7, CANADA</b><br>Tel: 1 (613) 632-5200 Fax: 1 (613) 632-5246 www.dartaero.com                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                       |                                                       |                                                                                                                                                                                                                                                                                                                                            |                          | 5. Work Order/Contract/Invoice<br><br>4801724643/01 |                                   |
| 6. Item:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 7. Description:                                       | 8. Part Number:                                       | 9. Quantity:                                                                                                                                                                                                                                                                                                                               | 10. Serial/Batch Number: | 11. Status/Work:                                    |                                   |
| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | AW119 Landing Gear Assembly – Standard OEM Protection | D119-796-021                                          | 1                                                                                                                                                                                                                                                                                                                                          | S0788648                 | New                                                 |                                   |
| 12. Remarks:<br>Note:<br>The following actions are required by the installer according to customer's request:<br><br>Rear Crosstube requires the installation of Center Support P/N D5122-1 and Clamps P/N MS21920-XX according to ICA-D119-796 Revision 3 Chapter 32.4                                                                                                                                                                                                                                                                                                                                               |                                                       |                                                       |                                                                                                                                                                                                                                                                                                                                            |                          |                                                     |                                   |
| 13a. Certifies that the items identified above were manufactured in conformity to:<br><br><input checked="" type="checkbox"/> Approved design data and are in a condition for safe operation.<br><input type="checkbox"/> Non-approved design data specified in Block 12.                                                                                                                                                                                                                                                                                                                                             |                                                       |                                                       | 14a. <input type="checkbox"/> CAR 571.10 Maintenance Release<br><br><input type="checkbox"/> Other regulations specified in Block 12<br>Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12, has been performed in compliance with the <i>Canadian Aviation Regulations</i> . |                          |                                                     |                                   |
| 13b. Signature<br>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                       | 13c. Approval Organization Number<br><br>9-89         |                                                                                                                                                                                                                                                                                                                                            | 14b. Signature           |                                                     | 14c. Approved Organization Number |
| 13d. Name<br><br>Eric Downing                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                       | 13e. Date (dd/mm/yyyy):<br><br>11/Jul/2018            |                                                                                                                                                                                                                                                                                                                                            | 14d. Name                |                                                     | 14e. Date (dd/mm/yyyy):           |
| 30 Dec 2008(Previously form 24-0078)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                       |                                                       |                                                                                                                                                                                                                                                                                                                                            |                          |                                                     |                                   |
| <p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than the authority specified in Block 1, must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements 13a or 14a do not constitute installation certification. In all cases, the aircraft technical record must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p> |                                                       |                                                       |                                                                                                                                                                                                                                                                                                                                            |                          |                                                     |                                   |



- 32.2.8 Loosely install fwd crosstube using OEM hardware in accordance with Aircraft Maintenance Manual (reference Figure 32.1).
- 32.2.9 Install OEM 109-0570-32-111/-112 Damper Assemblies in accordance with Aircraft Maintenance Manual (reference Figure 32.2).
- 32.2.10 Attach the P/N A537A01AA01-0220 Grounding Strap onto the D5515-1 Grounding Clamp on both sides of the aft crosstube using the hardware shown in Figure 32.10. Torque the MS21042-4 Nut to 5.6-7.9 N-m (50-70 in-lbs).
- 32.2.11 Torque all OEM fasteners in accordance with Aircraft Maintenance Manual.
- 32.2.12 Lower the aircraft and remove hoisting equipment. Verify that the aircraft is set correctly onto the crosstubes.
- 32.2.13 If the D119-796-101/-201 Crosstubes are being installed with floats, ensure the MS21920-XX Clamps for the Peg Steps and the D5134-041/-042 Damper Supports are oriented so that the threads are pointing away from the float bags per Figure 32.9.

### **32.3 SUPPORT/CONTACT PAD REMOVAL**

Applicable supports include: D5124-1 Fwd Supports, D5122-1 Center Support, D5134-041/-042 Damper Supports, D5136-1/-2 Contact Pad and D5152-041/-043 Post Mounts.

**IMPORTANT:** Mark location of support/contact pad prior to removal in order to properly locate its position for re-installation.

- 32.3.1 Remove MS21920-XX Clamps and D5123-X Clamp Cushion from applicable support/contact pad.
- 32.3.2 Break the seal around the supports/contact pads. Remove adhesive between crosstube and support. Supports may have been installed with Proseal 890 or 3M DP460.

**CAUTION:** Ensure crosstubes are not damaged during removal of supports.

- 32.3.3 Remove remaining adhesive with scotchbrite. Saturate a clean cotton cloth with Methyl Ethyl Ketone (MEK), 4105S Wash'n'Wipe Degreaser, or equivalent and wipe the surface to clean the entire area.
- 32.3.4 Check underlying crosstube surface for damage and repair (if applicable) in accordance with Chapter 5.

### **32.4 SUPPORTS & CONTACT PAD RE-INSTALLATION**

Applicable supports include: D5124-1 Fwd Supports, D5122-1 Center Support, D5134-041/-042 Damper Supports, D5136-1/-2 Contact Pad and D5152-041/-043 Post Mounts.

- 32.4.1 Locate support/contact pad on the crosstube for installation of applicable supports using the location marks added prior to removal. Refer to Figure 32.6 and 32.7 for approximate location. Ensure paint finish of crosstube is intact; touch up as required per Chapter 5 (5.3.13) of this ICA.
- 32.4.2 Abrade mating surfaces of support/contact pad with 400-grit sandpaper. Abrade mating surface of crosstube with 180-grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe until there is no residue.
- 32.4.3 Install Supports/Pads with adhesives specified per Figure 32.6 or 32.7.



- 32.4.4 Install the D5123-X Clamp Cushions and MS21920-XX Clamps in accordance with Figure 32.6 and 32.7 while adhesive is wet. Torque clamps 9.0-11.3 N-m (80-100 in-lb). It is acceptable to use smaller or larger sized MS21920-XX Clamps. Ensure the nuts on the clamps face aft and that the nuts are in safety but not bottomed out.

**NOTE:** When re-installing D5152-041/-043 Post Mounts, apply clamping pressure using MS21920-XX Clamps or by temporarily installing the associated peg steps per Section 32.5. The peg steps may be removed once adhesive has cured.

- 32.4.5 Prior to installing crosstube on aircraft, allow supports to cure for 72 hours and recheck torque on clamps is between 9.0-11.3 N-m (80-100 in-lbs).

## **32.5 D119-796-011/-013 PEG STEP REMOVAL/INSTALLATION**

- 32.5.1 Remove D119-796-011/-013 Peg Steps by removing MS21920 Clamps and associated hardware (reference Figure 32.8 and 32.9).
- 32.5.2 Check underlying crosstube surface for damage and repair (if applicable) in accordance with Chapter 5.
- 32.5.3 Re-Install D119-796-011/-013 Peg Steps in accordance with Figure 32.8 & 32.9.
- 32.5.4 Torque MS21920 Clamps 4.5-5.6 N-m (40-50 in-lbs). It is acceptable to use smaller or larger sized MS21920-XX Clamps. Ensure the nuts on the clamps face aft and that the nuts are in safety but not bottomed out.
- 32.5.5 If the D119-796-011/-013 Peg Steps are being installed with floats, the MS21920-XX Clamps for the Peg Steps **MUST** be oriented so that the threads are pointing away from the float bags in accordance with Figure 32.9.
- 32.5.6 Update the aircraft log book to indicate installation/removal of the D119-796-011/-013 kit and adjust weight and balance record for the aircraft with the weight and balance data provided in Section 32.9 of this document.

## **32.6 D119-796-021/-023/-025/-031/-033/-035 COMPLETE LANDING GEAR REMOVAL**

- 32.6.1 With the helicopter supported but not raised on hoist, remove the 4 bolts and washers at each of the two fwd crosstube clamps (OEM PN: 109-0570-20-101 Clamp Assy) that secure the fwd crosstube to the structure (reference Figure 32.1).
- 32.6.2 Remove Damper Assemblies from the aft crosstubes per applicable Aircraft Maintenance Manual (ref Figure 32.2).
- 32.6.3 Remove aft crosstube center support bolt (OEM PN: 109-0570-10-103 Bolt) and associated hardware (reference Figure 32.3).
- 32.6.4 Raise helicopter and remove assembled landing gear.